

Date: Thursday, 23/04/2009 3:29:28 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOUBLER
<b>Job Number</b> : 47424	
<b>Estimate Number</b> : 11317	
<b>P.O. Number</b> :	<b>Part Number</b> : D33021
<b>This Issue</b> : 23/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3302 REV B2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B2
<b>Previous Run</b> : 39847	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 08/05/2009 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JD 09.04.24</u>	
<b>Comment</b> : Est Rev: A 04.09.02 New issue KJ/JLM Est Rev:B Now on Waterjet 07-06-25 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S063	6061-T6 .063 Sheet
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**Comment:** Qty.: 0.8093 sf(s)/Unit Total : 8.0934 sf(s)  
 6061-T6 .063 Sheet  
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick  
 (M6061T6S.063)  
 Identify for D3302-1  
 Batch: 110551 B 9-5-07

2.0	WATER JET 110551	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3302  
 Dwg Rev: B2  
 Prog Rev: B2

B 9-5-07

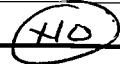
2-Deburr if necessary

B 9-5-07

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

B 9-5-07**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK809105107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 23/04/2009 3:29:28 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 47424

Part Number: D33021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges 0.005 to 0.010

SR 09/06/09

10

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3302

SR 09/06/09

10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SR 09/06/09

10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-06-10

10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-10

10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 232

9/6/10

SR

10

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/11

Job Completion



MF 09-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

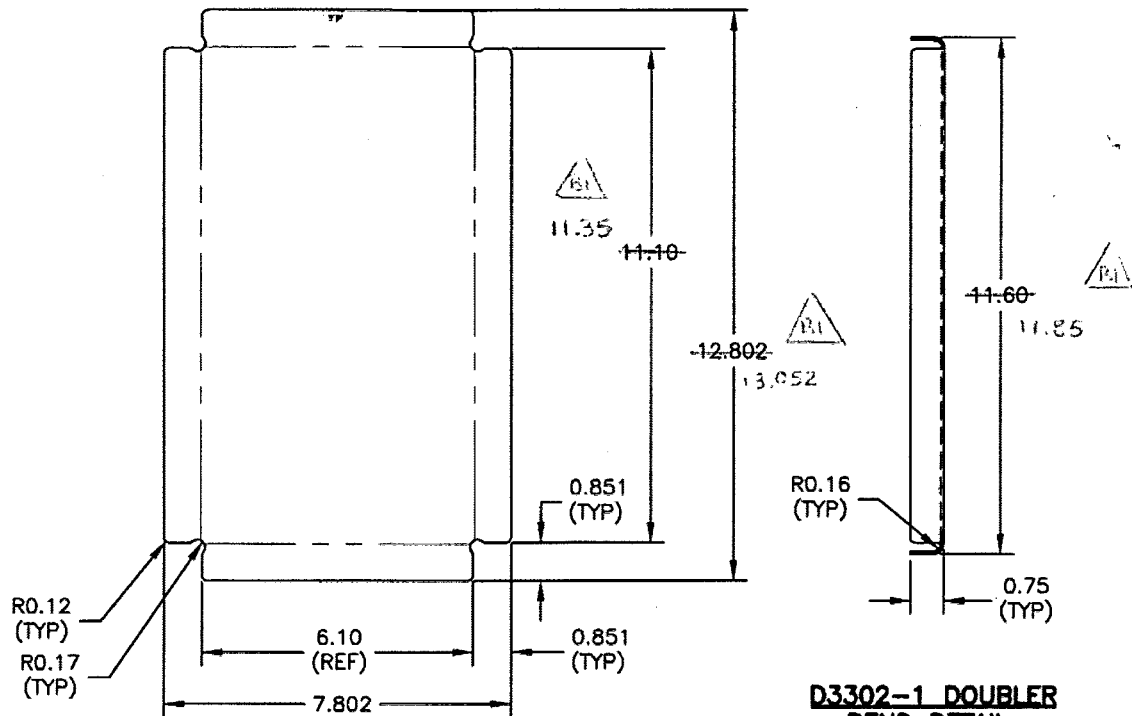
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



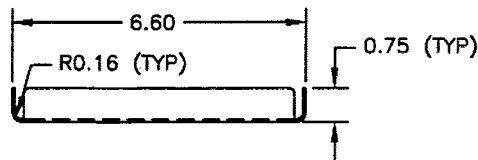
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CHECKED TH	APPROVED TH	DRAWING NO. D3302	REV. B SHEET 1 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
B1	TH 04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/-3	
B2	TH 05.03.21	7.25 WAS 7.34; 8.95Z WAS 9.042; 7.75 WAS 7.84 FOR D3302-3	

RELEASED  
04.11.23



**D3302-1 FLAT PATTERN**

**D3302-1 DOUBLER  
BEND DETAIL**



D3302-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WITHOUT NOTICE

## WORK ORDER

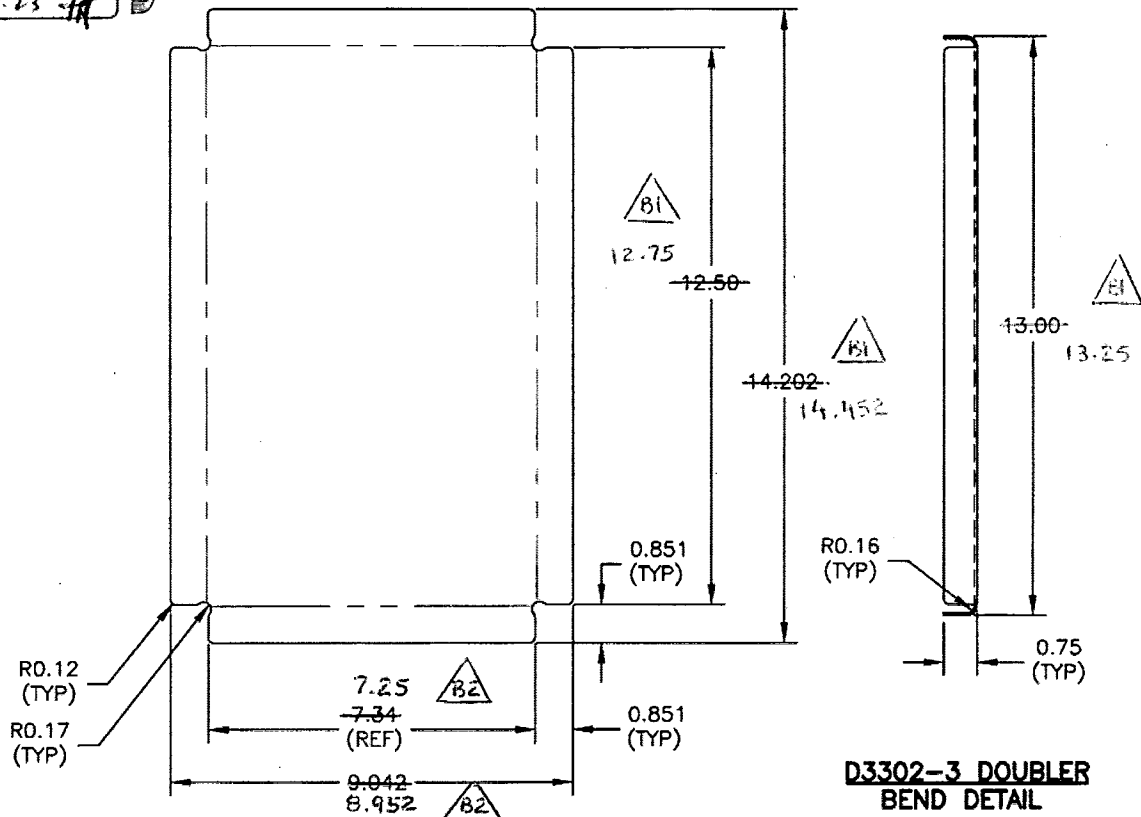
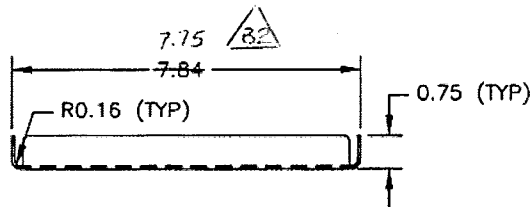
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CHECKED JA	APPROVED JA	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

**RELEASED**  
04.11.23**D3302-3 FLAT PATTERN****D3302-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

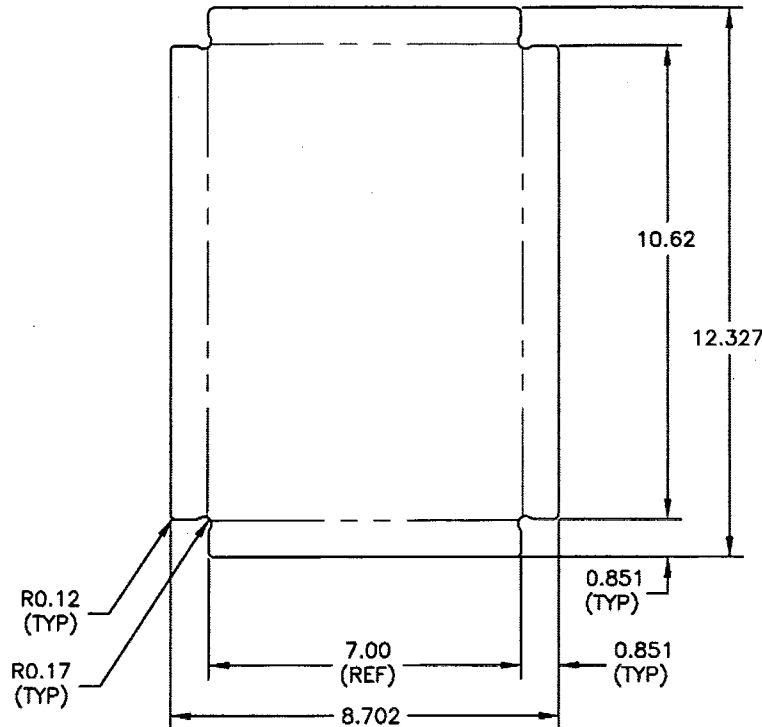
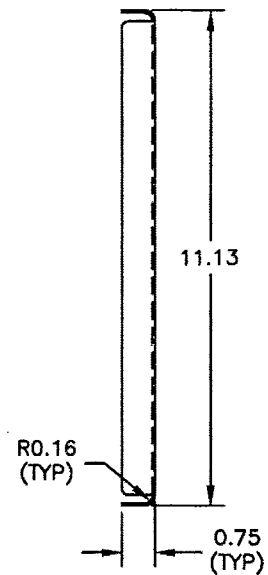
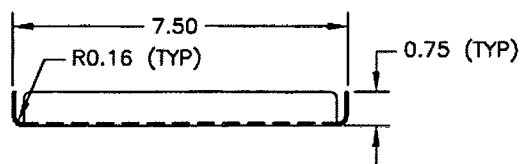
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DATE 04.11.08	TITLE DOUBLER		SCALE 1:4

**RELEASED**  
04.11.23 JF**D3302-5 FLAT PATTERN****D3302-5 DOUBLER  
BEND DETAIL****D3302-5 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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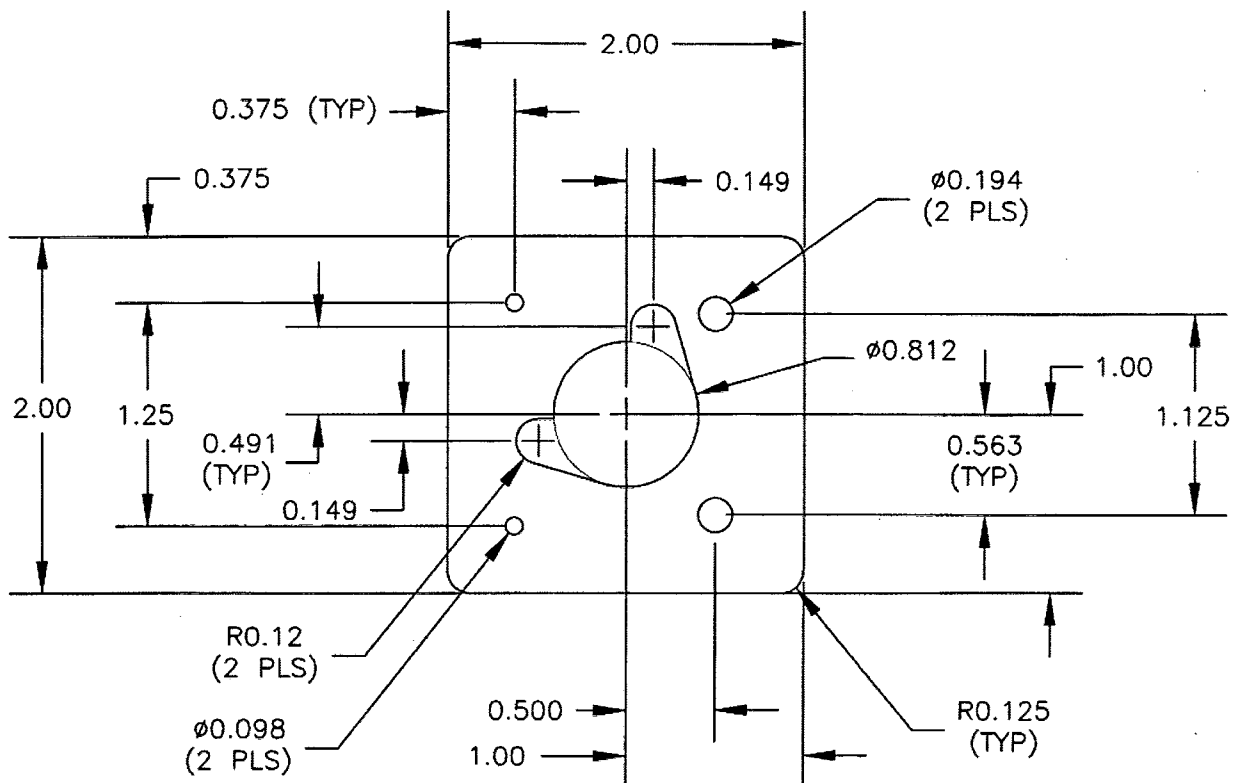
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CHECKED RF	APPROVED RF	DRAWING NO. D3302	REV. B SHEET 4 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:1

**RELEASED**  
04.11.23**D3302-7****D3302-7 NOTES:**

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11)  
0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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